

# Work Order ID 58524

Monday, May 10, 2010 9:17:36 AM



Page 1

Item ID:	D3413-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Ring					
Start Date:	5/10/2010	Start Qty:	20.00		Cust Item ID:	
Required Date:	5/14/2010	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>10-5-10</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3413	Rev A								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3413								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								

HB 10-5-10

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

HB 10-5-10

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

S. 10/05/10

winter  
f20

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1								
									<i>=&gt; m-h 10/05/11 20X</i>
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									<i>Sc 10/05/12</i>
									<i>counted 20</i>
150 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:00am								
	FINISH TIME: 10:30am								
	OVEN TEMPERATURE: 400°F								
									<i>=&gt; JH 10/05/12 20</i>

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**Work Order ID 58524**

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Item ID: D3413-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Ring

Start Date: 5/10/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20 BR 10-5-12

170

Identify as per dwg &amp; Stock Location: 473

0.00



Packaging

Memo

0.00

Packaging

10-5-12 54/20

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/17 JH

BR 10-5-13

(20)

W/O:			WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Monday, May 10, 2010 9:17:35 AM

Page 1

Work Order ID: 58524



Parent Item: D3413-1



Parent Item Name: Ring

Start Date: 5/10/2010

Required Date: 5/14/2010

Comments: IPP Rev:A ☐ 05.09.13 ☐ New issue ☐ KJ/JLM  
IPP Rev:B Now on Waterjet 07-05-28 JLM

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304B0.250X4.000		Purchased	No			100	f	14.0000	0.25			



304 BAR .250 x 4.00



1310-5-10

Location

Loc Qty

Loc Code

MAT53

14

113084

14

113084

20

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**NOTE:** Date & initial all entries





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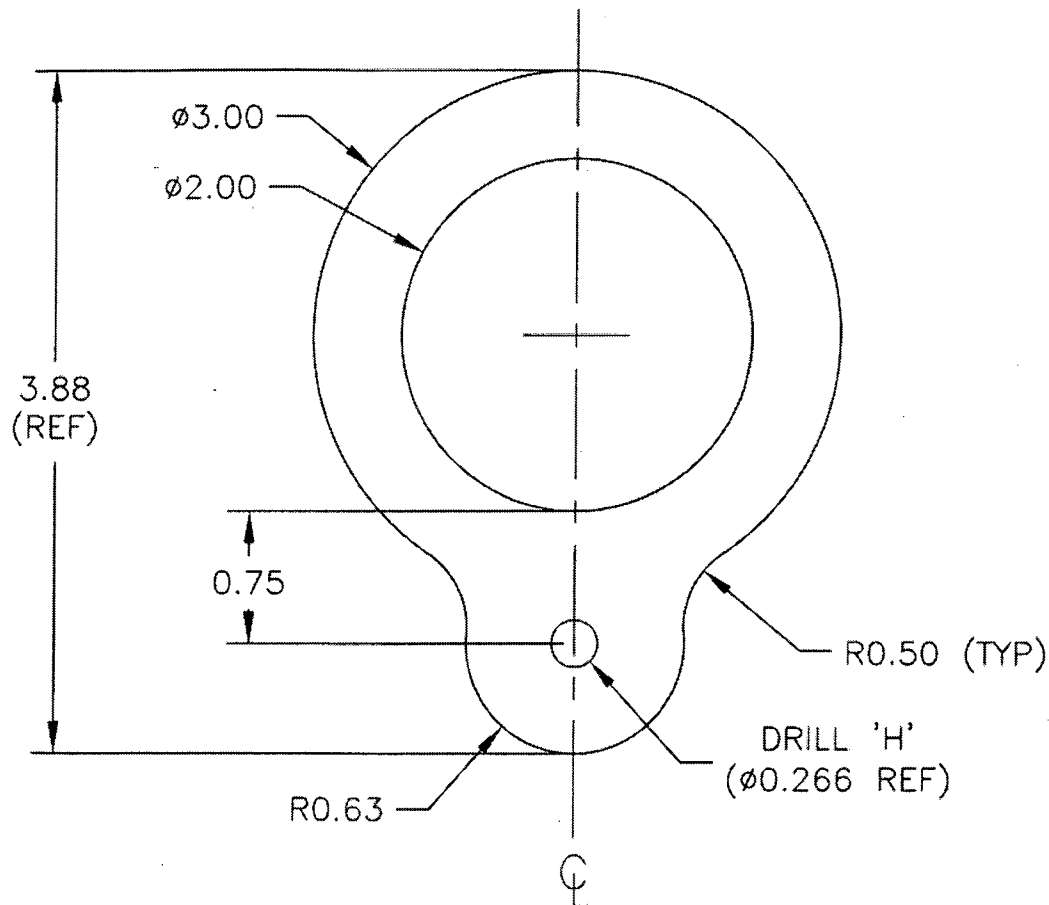
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

#58524

RELEASED  
05-09-06 #



### D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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